



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-143
Job Sheet 167106



Part No: D4635-143

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	D.M.L 17-12-12
100	Small Fab	1 pcs		11/9/17	0.00	0.68	Small Fab	D.M.L 17-12-12
110	Small Fab	1 pcs		11/10/17	0.00	0.68	Small Fab	D.M.L 17-12-12
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	D.M.L 17-12-12
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-14
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	DEC 14 2017

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138016 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/22 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: T4

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-3-164294	1	2	0	0
	37-04 D4669-1 154904	1	27	0	0
	38-03 D4669-3 117690	1	38	0	0
	5-55446 D4695-3 154798	1	5	0	0
	05 D4732-1 159197 5006605	1	6	0	0
	05 D4732-13 123306	1	6	0	0
	05 D4732-37 123218	1	3	0	0
	D5022-3-123319	1	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 12:51 PM dart.poulin.mario

5 020540

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

DISPOSITION

AGAINST DEPARTMENT/PROCESS

 Rework ☐
 Scrap ☐
 Use-as-is ☐
 approved ☐

 Skid-tube ☐
 Machining ☐
 Thermoforming ☐
 Large Fab ☐

 Cross tube ☐
 Small Fab ☐
 Finishing ☐
 Composite ☐

 Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

 Engineering ☐
 Quality ☐
 Other ☐

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

 ntric
 /Wave
 oe

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

 Mfg Date: 12/12/17
 Job No: 167106

D4635 - 143

Small Fab

 PART NO:
 Revision:
 Operation:
 Change No:

Aft Ceiling Replacement Panel Assembly, LH

 Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632 - 5200
 Email: sales@dartaero.com
 www.dartaerospace.com

S020540

Past Expiry Date ☐Manufacturing Process ☐Misidentified ☐Past Due ☐OTHER : ☐